

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011450**Date Inspected:** 10-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Xian Ping**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG/Tower Subassemblies**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Stefan Holmes was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China.

QA Inspector observed the following work in process:

FCAW welding of WSD1-DPSA4-6B/B-3 by welding operator 0222396 utilizing WPS-B-T-4332-TC-P4-F.

FCAW welding of BK001-025-001/003 by welding operator 053742 utilizing WPS-B-T-2231-TC-U4c-F-1.

FCAW welding of BK001-028-001/003 by welding operator 058174 utilizing WPS-B-T-2231-TC-U4c-F-1.

FCAW welding of 11TR2-017-003 by welding operator 0217185 utilizing WPS-B-T-2231-BU2-F.

FCAW welding of 10TR3-029-003 by welding operator 0217185 utilizing WPS-B-T-2231-BU2-F.

FCAW welding of CB202D-016-001 (CB8) by welding operator 0215248 utilizing WPS-B-T-2221-B-L2c-S-Z.

FCAW welding of CB202D-016-002 (CB8) by welding operator 0215248 utilizing WPS-B-T-2221-B-L2c-S-Z.

FCAW welding of CB202A-008-019 (CB8) by welding operator 051246 utilizing WPS-B-T-2232-TC-U4b-F.

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FCAW welding of FB205-018-030, FB205-017-030, and CB202A-008-002 (CB8) by welding operator 058174 utilizing WPS-B-T-2233-B-U2-F.

FCAW welding of FB205-019-030, FB205-020-030, CB202A-008-008, and CB202A-008-009 N(CB8) by welding operator 048625 utilizing WPS-B-T-2233-B-U2-F.

FCAW welding of CB202G-024-143/161 (CB9) by welding operator 067707 utilizing WPS-B-P-2113.

FCAW welding of CB202G-024-163/145 (CB9) by welding operator 053753 utilizing WPS-B-T-2113.

QA Inspector performed QA Verification MT following the guidelines of Caltrop MT Procedure CTMT-08-00 Rev. 2.1 on I-rib OBG deck panel assemblies and subcomponents. Items inspected and results are as follows:

SA6518-001-005/006;  
DP3011-001-007-012, 061/062;  
DP3033-001-001-006, 034/035;  
SA6518-001-007/008;  
DP510-001-001-006;  
DP105-001-001-006;

QA Inspector performed Final Visual Inspection following the guide lines of AWS-D1.5 on I-rib Deck Panel assemblies. Items inspected and results are as follows:

SA6518-001; VT appears to comply.  
DP3011-001; VT appears to comply. Green Tag #10641  
DP3050-001; VT appears to comply. Green Tag #10642  
DP3033-001; VT appears to comply. Green Tag #10643  
SA6518-001; VT appears to comply.  
DP3012-001; VT appears to comply. Green Tag #10644  
DP510-001; VT appears to comply. Green Tag #10475  
DP105-001; VT appears to comply. Green Tag #10474

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Holmes,Stefan

Quality Assurance Inspector

**Reviewed By:** Hall,Steven

QA Reviewer